

Work Order ID 160923

Friday, May 05, 2017 10:04:11 AM

160923

Page 1

Item ID: PB67-43001-173

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cover Plate

Start Date: 5/8/2017 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/31/2017 Req'd Qty: 12.00

12

Customer:

Reference: SCHEDULED/U

Approvals:

Process Plan:

DAS
21
9-00

Date: MAY 05 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001-173	D

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.77

FLOW CNC Waterjet

****Grain direction along 7.19" ****

1-Cut as per Dwg B67-43001

Dwg Rev: **D**Prog Rev: **D**

2-Deburr if necessary

(12)

05/17/17

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.12

Quality Control

(12)

05/17/17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER : _____							

Friday, May 05, 2017 10:04:11 AM

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N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 5/8/2017 **Start Qty:** 12.00

12

Customer:

Required Date: 5/31/2017 **Req'd Qty:** 12.00

12

Reference: SCHEDULED/U

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC8- Inspect parts - second check

0.00

120

0.24

QC

Memo

Quality Control

MAY 09 2017

130

0.21

130

NC BRAKE

0.52

Brake NC

Memo

Brake NC

Bend as per Dwg B67-43001

DAS
30
9-89

MAY 10 2017

140

QC5- Inspect part completeness to step on W/O

0.00

140

Memo

0.24

QC

Quality Control

MAY 10 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							

Work Order ID 160923

Friday, May 05, 2017 10:04:11 AM

160923

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Item ID: PB67-43001-173 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Cover Plate
Start Date: 5/8/2017 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 5/31/2017 Req'd Qty: 12.00 ***12*** Customer:
Reference: SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150 HandFinish Hand Finishing	Memo	2.32				(x12)	Ø		20170517 BEB.
160	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
160 Powdercoat Powder Coating	M134092 Memo START TIME: 9:35 OVEN TEMPERATURE: 325 FINISH TIME: 10:05	0.61				12	Ø	17-05-19	338 9-89
170	QC3- Inspect Part Finish	0.00							
170 QC Quality Control	Memo	0.12				12			DAS 38 9-89 MAY 19 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER : _____							

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1 60923

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N900040100

Setup Start *NS1*

Stop ***NS2***

Customer:

Start Date: 5/8/2017 **Start Qty:** 12.00 ***12***

Required Date: 5/31/2017 **Req'd Qty:** 12.00 ***12***

Reference: SCHEDULED/U

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 160923

Friday, May 05, 2017 10:04:11 AM

160923

Page 5

Item ID: PB67-43001-173 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Cover Plate
Start Date: 5/8/2017 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 5/31/2017 Req'd Qty: 12.00 ***12*** Customer:
Reference: SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 *220* QC Quality Control	QC6- All purchased or subcontracted products Memo	0.00 0.00				12			38 9-89 JUN 14 2017
230 *230* Packaging Packaging	Identify as per dwg & Stock Location <u>WAD63</u> Memo	0.00 0.12				12			DAS 6 9-89 JUN 14 2017
240 *240* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 1.20							17/6/14 JG DAS 21 9-89 JUN 14 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Friday, May 05, 2017 10:04:11 AM

Page 1

Work Order ID: 160923

160923

Parent Item: PB67-43001-173

PR67-43001-173

Parent Item Name: Cover Plate

Start Date: 5/8/2017

Required Date: 5/31/2017

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-06-20 new issue DD verified by:ec
10.10.04 per revC dwg EC verified by:DD

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	124.9400	1.0548	13.32379			

M2024T3S 032

2024-T3 .032 sheet

05/17/2017

Location

Loc Qty

Loc Code

MAT022

124.94

M134581

3

M135010

1.6

M135032

6

M136687

18.34

M137435

96

14.5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

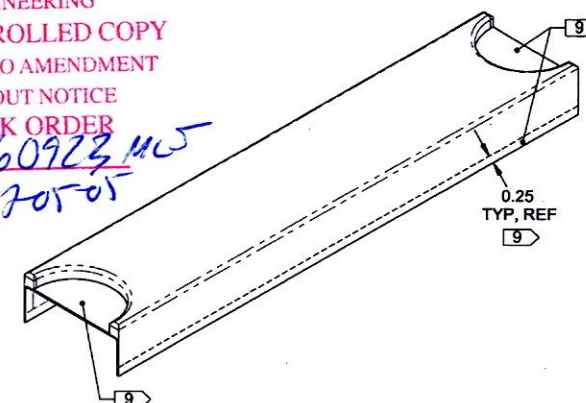
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
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Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
Misidentified ☐	☐	Past Due								

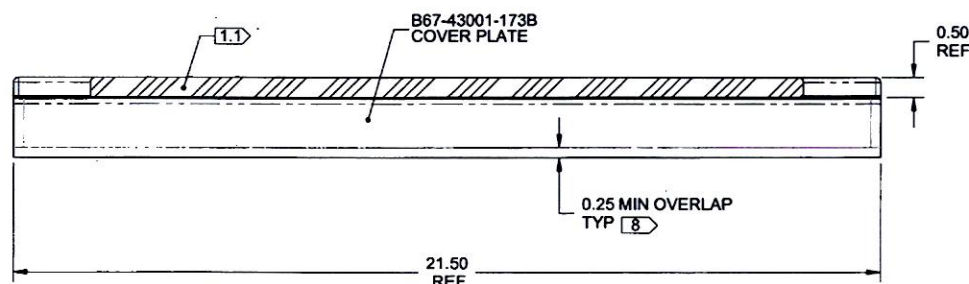
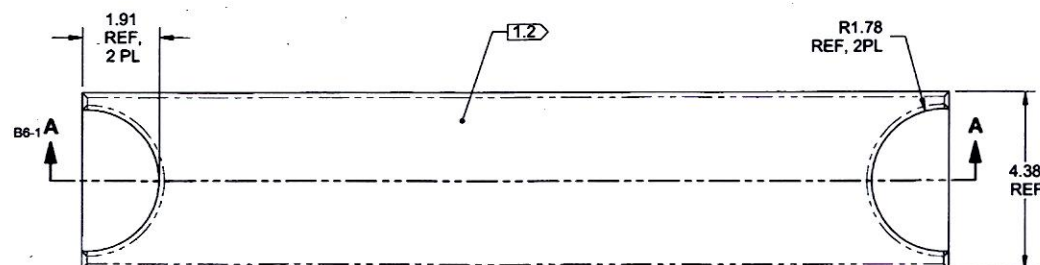
ITEM	QTY -173	P/N	DESCRIPTION
	X	B67-43001-173	COVER PLATE ASSEMBLY
1	1	B67-43001-173	COVER PLATE
2	A/R	FOAM	SEE NOTE 1.1
3	A/R	FABRIC	SEE NOTE 1.2
4	A/R	ADHESIVE	SEE NOTE 1.3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
WITHOUT NOTICE
WORK ORDER
NO. 160923 MJS
120505



RELEASED
2014-12-08

B67-43001-173 COVER PLATE ASSEMBLY



SECTION A-A D8-1

NOTES:

- 1) MATERIAL:
 - 1.1) FOAM: SBR/EPDM/CR BLEND, BLACK, ASTM D1056 2A2, 1/2" THICK, BRITTLINESS TEMP OF -40F, IAW ASTM D 746, FMVSS 302
 - 1.2) FABRIC: 100% 420 DENIER NYLON, MIN THREAD COUNT 35X35, POLYURETHANE COATED ONE SIDE, COLOUR: BLACK, REF. TULMAR P/N 1495
 - 1.3) ADHESIVE: URETHANE WITH CATALYST, TWO PART, CLIFTON LA4009 OR LA4009NOVOC
- 2) FINISH: BOND NEOPRENE TO COVER PLATE USING ADHESIVE. COVER WITH DENIER AS SHOWN.
- 3) TOLERANCES: PER TABLE 1 (ZN A3-1) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs REF
- 8) DENIER NYLON TO BE BONDED ALL AROUND INNER SIDES OF PLATE
- 9) DENIER NYLON TO BE BONDED TO PLATE ON OUTER SIDE

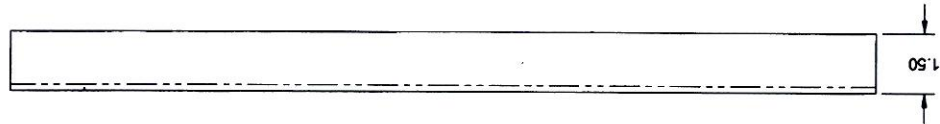
TABLE 1
TOLERANCES ON FABRIC
(PARTS AND ASSEMBLIES)

±1/8: DIMS <2
±1/4: DIMS 2 TO <10
±1/2: DIMS 10 TO <20
±5/8: DIMS 20 TO <40
±1.5%: DIMS EQUAL TO OR > 40

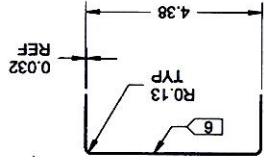
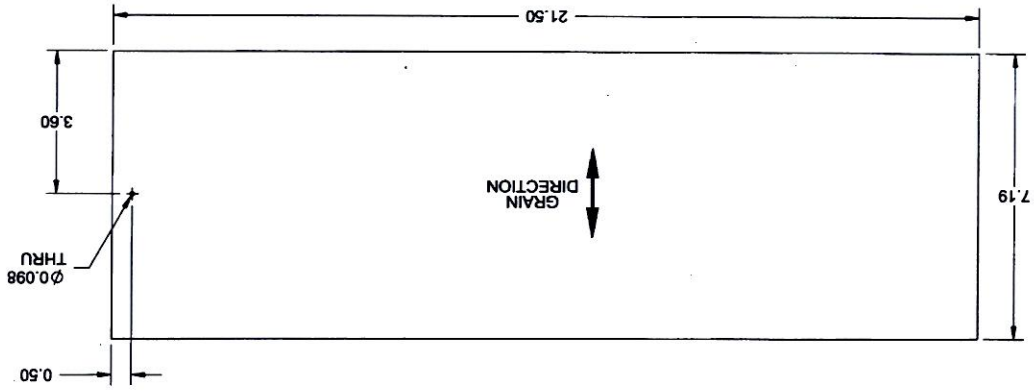
D	FOAM AND ADHESIVE SPECS CHANGE TO MATCH SUPPLIER MATERIALS REASON: SEE PAR #14-333	DB	14.07.14
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018, QSI 043 AND TULMAR SAFETY SYSTEMS INC.'S MANUFACTURING PROCESS AND TOLERANCES ON FABRIC: 4.38 WAS 4.25. FOR PREVIOUS REVISIONS, REFER TO SHEETS 10 AND 27 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	10.04.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RW		
DRAWN	DB		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.	N/A		
DATE	14.07.14		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-173 TITLE COVER PLATE SCALE NTS COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

NOTES:
 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
 PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
 REF. DART SPEC. M2024T3S.032
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-173B" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: 0.48 lbs

B67-43001-173B BENDING DETAIL
 (MAKE FROM B67-43001-173F)



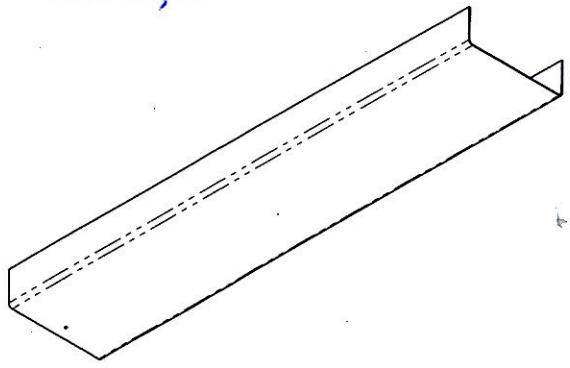
B67-43001-173F FLAT PATTERN



DESIGN	RW	DATE	14.07.14
DRAWN	DB	DE APPR.	N/A
CHECKED	R	APPROVED	
MFG. APPR.		TITLE	COVER PLATE
DRAWING NO.	B67-43001-173	SCALE	NTS
REV. D		SHEET 2 OF 2	
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			

RELEASED
 2014-12-08

NO. _____
 WORK ORDER
 WITHOUT NOTICE
 SUBJECT TO AMENDMENT
 UNCONTROLLED COPY
 ENGINEERING
 RETURN TO
 SHOP COPY





Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36403**

Purchase Order Date 5/23/2017

PO Print Date 5/23/2017

Page Number 2 of 2

From :
TULMAR SAFETY SYSTEMS
1123 CAMERON ST
HAWKESBURY, ON K6A 2B8
CA

VC-TUL001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613 632 1282

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

VENDOR'S TRUCK

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

FCA - (Free Carrier)

4

160923

PB67-43001-173 COVER
PLATE

6/14/2017

Yes

6/14/2017

FOAM AND FABRIC AS PER DWG PD67-43001-173 REV. D
TULMAR P/N: 8421-104

12.00

\$130.00

\$1,560.00

SP17-6-7

Line Total:

\$1,560.00

5

71401-45

PROCUREMENT
QUALITY CLAUSES

6/14/2017

No

6/14/2017

Procurement Quality Clauses

A004 faa-pma/tso

A005 right of entry

A007 first article inspection (fai)

A016 personnel qualification

A026 certification of material conformance

A040 notification of quality escape

A041 quality management system

A043 retention of quality document

TSS = 5 YRS ONLY

1.00

\$0.00

\$0.00

SP17-6-7

Line Total:

\$0.00

PO Total:

\$2,078.20

CL

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 5/23/2017

PACKING SLIP

TULMAR

Tulmar Safety Systems Inc.
1123 Cameron Street
Hawkesbury, ON K6A 2B8

Tel: 613-632-1282
Fax: 613-632-2030
GST R132478223
MID : XOTULSAF1123HAW
email: info@tulmar.com

Packing Slip No Page

60402 1

Ship Date
6/5/2017

Bill To:

Dart Aerospace
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship To:

Dart Aerospace
1270 Aberdeen Street
Tel: 613-632-9577
Hawkesbury, ON K6A 1K7
Canada

Order number	Sales order date	Account number	Loc	Account manager	PO number	Ship via	Shipping Terms
34911	5/25/2017	CDART100	H	Francine Bigras	PO36403	Pick-Up	FOB HAWKESBURY
Item No.	Description	Quantity ordered	UOM	Qty Shipped/Returned	Quantity on back order		

Line 5 - Procurement QA Clauses:
A004 A005 A007 A016 A026 A040
A041 A043(TSS=5 yrs only)

8421-104
Cover Plate

Drawing No: B67-43001-173

DWG Rev: D

Line 4

SF 42143

CUSTOMER PICKUP

Lot no.: BATCH0000000013

12.00

EA

12.00

801767

Certificate of Conformance

☒ See Certification Enclosed

I hereby certify that the items listed hereon have been inspected, and / or tested (as applicable), conform to all specifications and requirements detailed in the contract or purchase order. Objective evidence to support this statement is on file, and can be made available upon request.

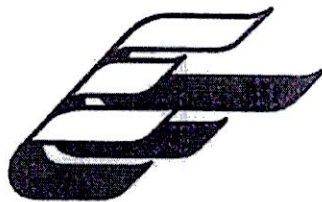
If any questions or concerns, please contact QA Manager @ 613-632-1282 ext. 245.

Authorized Inspector

Suzanne LaLiberté

Date:

JUN 05 2017



J. ENNIS FABRICS

CERTIFICATE OF CONFORMANCE

January 21, 2016

Tulmar Safety Systems Inc.
1123 Cameron Street
Hawesbury, Ontario
K6A 2B8

Attention: Allan Chalot
E-Mail: allan@tulmar.com

Customer Purchase Order Number: 29645-00
J. Ennis Fabrics Reference Number: 03406993 T1

The following item/s is supplied under the stated reference:

- Oxford 7
- Description: oxford 7 Black
- Backing Content: 100% Polyurethane
- Coating: Product has a Polyurethane
- Construction: 0420 Denier
- Content: 100% Nylon
- Description: High Density Nylon, Piece Dyed, PU coated
- Features: Phthalate Free
- Weight: 5.98 ounces per square yard. 8.98 Ounces per Linear yard
- Width: 58"(147 cm)
- Hydrostatic Resistant: AATCC 127(Suter)-Average 800 mm
- Protective Finish: DWR Durable Water Repellant

This is to certify that the product/s stated herein have been manufactured in accordance to the specifications stated by the manufacturer as well as the specifications stated on your order

Sincerely;

J. Nykolyshtyn
Jennifer Nykolyshtyn
Customer Service Center

JAN 29 2016



1495
B# 34

2/c's used to mfg. B67-43001-173

Rev. D.

Sonia Laliberté (oc)
5/17

TULMAR**Certificate of Conformance**

Tulmar P/N 1637-001	Description 1/2" X 42" X 72"	Dwg #	Revision	Qty 4
Tulmar PO # 30168-00	Line Item # 01	Supplier Name / Address AM RUBBER & FOAM GASKETS INC 2074 STEELES AVE EAST UNITS 1 & 2 BRAMPTON, ON L6T 4Z9		Supplier Packing Slip # 16428

Supplier Declarations:

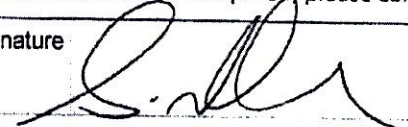
Hazardous Materials Acknowledgement	The items described below may contain, and their processing may have included, the following substances:	Hexavalent Chromium; Cadmium; Beryllium; Nickel; Mercury; Lead; Asbestos; Radioactive elements YES ☐ NO ☒
Country of Origin of Goods : CANADA		if YES, please complete the HazMat Acknowledgement form @ www.tulmar.com
Limited Shelf-Life	<u>Definition:</u> If material is consumed or transformed into final product before end of shelf-life there is no effect on final product.	These items have a limited Shelf-Life YES ☐ NO ☒
Expiry date	<u>Definition:</u> Date after which performance will no longer be as intended - expiration is transferred to the final product.	These items have an expiry date YES ☐ NO ☒

if YES, please complete the Time Expired - Shelf-Life questionnaire @ www.tulmar.com

Additional Information (MRS#, MRA#, limitations, etc...):

FOAM, SBR/EPDM/CR BLEND, BLACK
ASTM D1056 2A2, 1/2"TH.
SHEET SIZE 42" X 72" +/-0.5"
BRITTLENESS TEMP OF -40 DEGREES F
IAW ASTM D746, FMVSS 302.
QUALITY CLAUSE: GrBT3

I hereby certify that the goods listed hereon have been inspected and/or tested, as applicable, and conform to all specifications and requirements detailed in the contract or purchase order and relevant quality clauses. Objective evidence to support this statement is on file and can be made available upon request. Should further information be required, please contact:

Signature 	Name SANDRA PULSINELLI	Date (DD-MMM-YYYY) 07-06-2016
Title PRODUCTION	Email sandra@amrubber.ca	Phone # 905-455-1449

1637-001**JUN 16 2016**

Form Revision 13 Aug 2012

3#9



48 Burgess Place
Wayne, NJ 07470

Certificate Of Analysis

2/17/2017

Sales Order Number: 9425
Customer Order Number: 30970

Manufactured for
TULMAR SAFETY SYSTEMS

4172-C6.9A LA4009NOVOC, P/N 7122-001 14172-C6.9A - LA4009NOVOC, UNLINED GALLON CAN

Lot# PNJ-0117-0331 Qty: 53 CANS + PART CAN @ 3# Manufacture Date: 2/1/17 Expiration Date: 2/1/18

Test(s)	Results	Min	Max	
% Solids @275F for 30 minutes	15.0000	13.00	15.00	Percent
Brookfield,RVT,#3 Spindle,20RPM,78F	1,015.0000	800.00	1,500.00	Centipoise
Visual check for dry film color	pass	(CLEAR TO HAZY YELLOW) PASS/FAIL		

4556-S1.9 CAT7020, P/N 7153-002 14556-S1.9 - CAT7020 QUART CANS SQUARE UNLINED

Lot# PNJ-0117-0329 Qty: 11 EA Manufacture Date: 2/14/17 Expiration Date: 8/14/17

Test(s)	Results	Min	Max
	NOT APPLICABLE	NA	NA

4914-C7 DB7020M1, P/N 7153-001 14914-C7 - DB7020M1, GALLON LINED CAN

Lot# PNJ-0117-0332 Qty: 52 CANS + PART CAN @ 5# Manufacture Date: 2/3/17 Expiration Date: 8/3/17

Test(s)	Results	Min	Max	
% Solids @275F for 30 minutes	23.7000	21.00	24.00	Percent
Brookfield,RVT,#3 Spindle,20RPM,78F	835.0000	450.00	1,250.00	Centipoise

"The material supplied conforms to all applicable engineering drawing, specifications and PO requirements."

Dan Constantino

Daniel Constantino
Quality Assurance Mgr/ISO Coordinator

Country of Origin: USA

7122-001
B#10

FEB 28 2017

